

Work Order ID 61356

Thursday, August 19, 2010 1:13:25 PM



Page 1

Item ID:	D3575-6	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cabin Floor Protector					
Start Date:	8/19/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	8/23/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>wf</u>	Date:	<u>10-8-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3575	Rev A

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3575 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								

B10-9-2

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B10-9-2

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

S 10/09/07

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Deburr if necessary.

8/10/09/06 (2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/09/07

(2)

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

PDP 61360

Cca/9 (2)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/09

P10-9-09
(2)

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 61356



Parent Item: D3575-6



Parent Item Name: Cabin Floor Protector

Start Date: 8/19/2010

Required Date: 8/23/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,704.423	10.666	22.45474			
GE PLASTICS LEXAN SHEET													

IB 10-9-2

Location

Loc Qty

Loc Code

MAT

2704.4238

114032

467.9238

115261

2236.5

114032

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DART AEROSPACE LTD		Work Order: 61356
Description: Cabin Floor Protector		Part Number: D3575-6
Inspection Dwg: D3575	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	X		T 1801	
3.38	+/-0.030	3.38	X		T	
6.50	+/-0.030	6.50	X		T	
26.13	+/-0.030	26.13	X		T	
30.13	+/-0.030	30.13	X		T	
2.00	+/-0.030	2.00	X		T	
3.50	+/-0.030	3.50	X		T	
14.25	+/-0.030	14.25	X		T	
25.13	+/-0.030	25.13	X		T	
29.38	+/-0.030	29.38	X		T	
30.38	+/-0.030	30.38	X		T	
31.50	+/-0.030	31.50	X		T	
1.00	+/-0.030	1.00	X		T	
4.38	+/-0.030	4.38	X		T	
14.50	+/-0.030	14.50	X		T	
16.00	+/-0.030	16.00	X		T	
23.13	+/-0.030	23.13	X		T	
26.88	+/-0.030	26.88	X		T	
27.69	+/-0.030	27.69	X		T	
1.00	+/-0.030	1.00	X		T	
3.75	+/-0.030	3.75	X		T	
9.63	+/-0.030	9.63	X		T	
16.13	+/-0.030	16.13	X		T	
28.06	+/-0.030	28.06	X		T	
32.15	+/-0.030	32.15	X		T	

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 10-9-2	Date: 10/09/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ//DD	AS

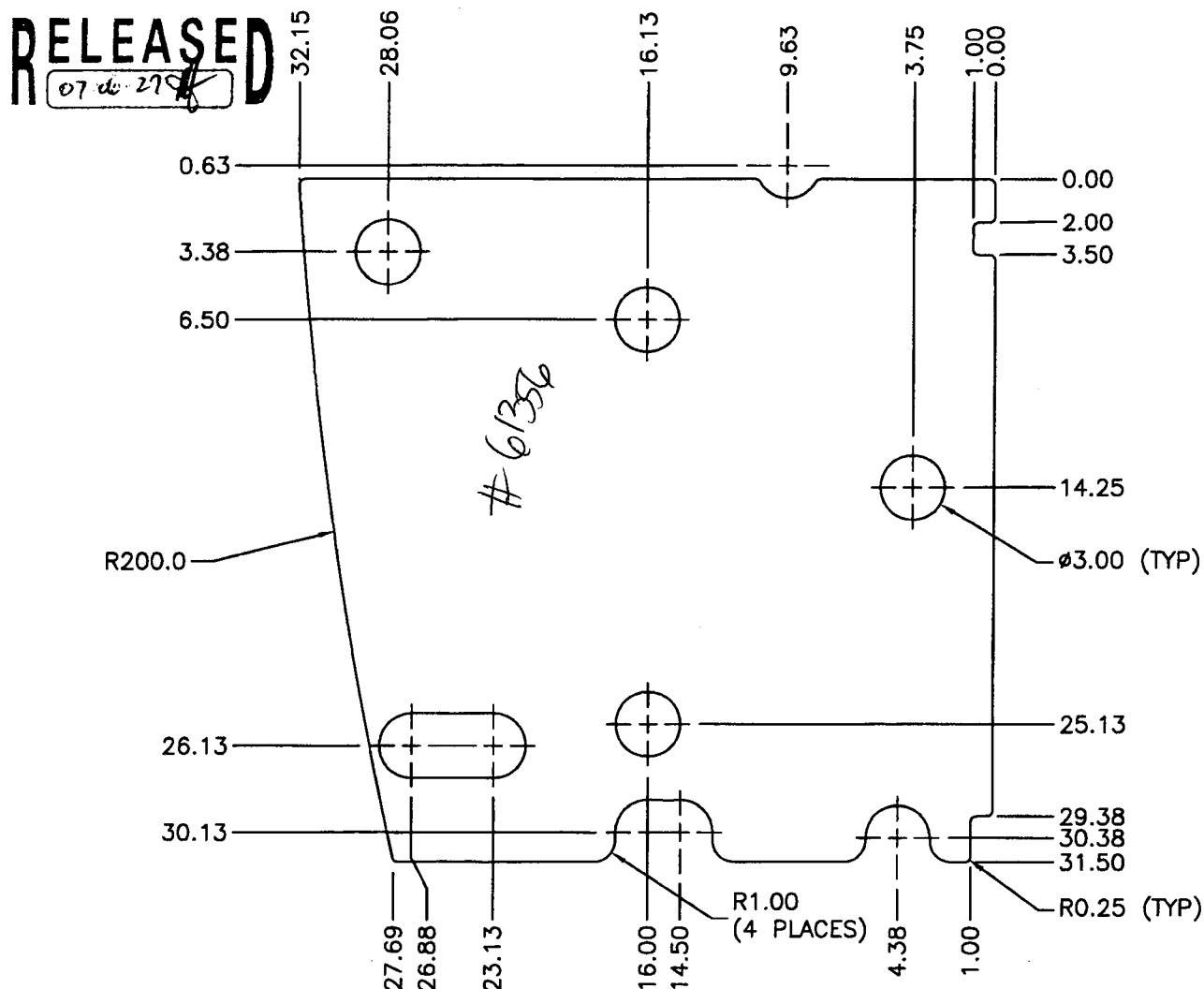
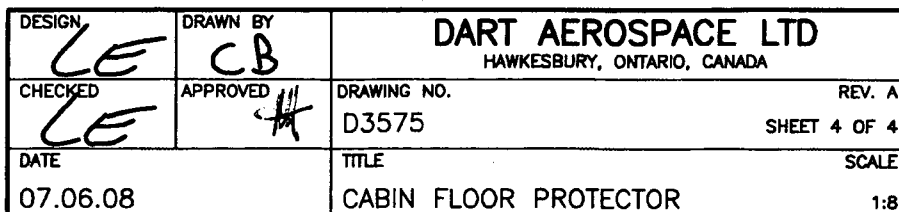
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D3575-5 CABIN FLOOR PROTECTOR (SHOWN)
D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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